

Split

Work Order ID 110249 -2

110249

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December-17-13 9:19:16 AM

Item ID: 646.9601

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Upper Cutter Assy

Start Date: 12/19/13 Start Qty: 2.00

Cust Item ID:

Required Date: 12/19/13 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: MCS Date: 13-12-17 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
546.9600	N/C

110 Pick Kit 0.00

110

Packaging

Memo 0.00

Packaging

(6) SAO 14/05/03

120 0.00

120

Small Fab

Memo 0.00

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: M127443
exp. date: OCT 2015

6 SAO 14/05/03

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo 0.00

Quality Control

PTO

DQA:

Date:

14/05/16



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

14/5/19

Work Order update only ☐

Work Order: <u>110249</u>	DISPOSITION Rework <input checked="" type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>646-9601</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14/5/19</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input checked="" type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14/5/19	120	1	touch up with tempo grey Def+ RC handy of part	DAS 16 9-89 14/5/19 02017	tempo grey Def+ B# 127401	CR 17-05-06	M/5/17	DAS 16 9-89 02012 14/5/17
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material <input checked="" type="checkbox"/>									
Operator <input checked="" type="checkbox"/>									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread	<input checked="" type="checkbox"/> Other
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	<u>miss handling of part</u>
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence	

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Work Order ID 110249

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Item ID: 646.9601 Accept *N900040100*

Revision ID:

Item Name: Upper Cutter Assy

Start Date: 12/19/13 Start Qty: 2.00 *2*

Required Date: 12/19/13 Req'd Qty: 2.00 *2*

Reference:

Cust Item ID:

Customer:

Setup Start *NS1*

Stop *NS2*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>ST428A</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER IAW MPP-120***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

1/X DAS 28 9-89 MAY 08 2014

ML9 1405-08

14-05-08

Picklist Print

December-17-13 9:19:15 AM

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Work Order ID: 110249
 Parent Item: 646.9601
 Parent Item Name: Upper Cutter Assy

Start Date: 12/19/13
 Start Qty: 2.00

Required Date: 12/19/13
 Required Qty: 2.00

Comments: IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701 Cutter Sub Assembly		Manufactured	No			110	Each	17.0000	1	SAB 14/05/03			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				CA		17							
				89707		5							
				91788		12	B112549						
646.9811 Upper Deflector		Manufactured	No			110	Each	5.0000	1	SAB 14/05/03			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				CA		5							
				106375		1							
				106775		4	109920						
MS21042L08 Nut		Purchased	No			110	Each	4.583.0000	3	SAB 14/05/03			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST314		113							
				122141		3							
				122452		9							
				123900		101							
				ST505		100							
				125445		100							
				ST508		3400							
				125445		1900							
				m127410		1500							
				ST509		970							
				m127304		970							

Picklist Print

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Work Order ID: 110249
 Parent Item: 646.9601
 Parent Item Name: Upper Cutter Assy

Start Date: 12/19/13
 Start Qty: 2.00

Required Date: 12/19/13
 Required Qty: 2.00

MS27039-08-19 Purchased No

110 Each 2,703.0000 3

SAD⁶ 14/05/03

Screw

Location	Loc Qty	Loc Code
ST308	102	
123525	89	
m126474	13	
ST309	82	
125654	82	
ST506	2519	
124309	1200	
125654	189	
m127305	730	
m127410	400	m124309

NAS1149FN832P Purchased No

110 Each 13,170.000 6

SAD¹² 14/05/03

Washer

Location	Loc Qty	Loc Code
ST295	3194	
123522	398	
123900	2796	
st510	9976	
125268	9976	

72

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PR	DESCRIPTION	DATE	APPROVE
1001	ADDITIONAL WORK		YAC
1002	ADDITIONAL	04/23/08	P. SPANIO



0.2743

1. IDENTIFY IAW MPP-120
2. APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 6, 7, & 8 UPON ASSEMBLY

1			1	646.9813	LOWER DEFLECTOR LOW		
	1		7	646.9812	LOWER DEFLECTOR HIGH		
		1	6	646.9811	UPPER CUTTER DEFLECTOR		
A/R	A/R	A/R	3	601.2045	RTV, LOCITE 598		
3	3	3	4	601.1541	LOCKNUT	MS2-104208	
3	3	3	3	601.2765	SCREW	MS21999-08-03	
6	6	6	2	601.2764	WASHER	FASTORNS-8321	
1	1	1	1	646.9701	CUTTER SUB ASSY		
				646.9603	LOWER CUTTER ASSY LOW		
				646.9602	LOWER CUTTER ASSY HIGH		
				646.9601	UPPER CUTTER ASSY		
9603	9602	9601	FINISH	PART #	DESCRIPTION	AMTL	SPEC
QTY				PART LIST			
NEXT ASSY (2)		646.9500		646.9500 LOWER CUTTER ASSY LOW 2508 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92036-3512 (760) 724-5313 CATERPILLAR		646.9600 LOWER CUTTER ASSY HIGH	

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02743				SHEET 1 OF 1	
	DWG NO. 646.9600		REV IN/C	PREPARED BY S. HUFF	DATE: 01/07/10	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.
	DWG TITLE: CUTTER ASSY					
	APPROVED BY:	ENGR. <i>P. Brane</i>	MFG. <i>Amel G...</i>	QC. <i>Wendy L...</i>	EFF: NEXT ORDER	
TRANSACTION A-ADD R-REVISE	CODES (TC) C-CREATE D-DELETE	REASON: REVISED SCREW LENGTH.				

110249 MJS
13-12-17

3	R	601.3157	3	3	3	SCREW	MS27039-0818
			.9603	.9602	.9601		
F/N	TC	PART NUMBER	QTY		DESCRIPTION		MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED: <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUCC <input checked="" type="checkbox"/> ICA <input type="checkbox"/> FMS <input checked="" type="checkbox"/> BOM							CHANGE CATEGORY <input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR
							DER REVIEW REQUIRED <input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

